

Date: Monday, 27/04/2009 12:51:16 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 47532	
Estimate Number : 12806	
P.O. Number :	Part Number : D35702
This Issue : 27/04/2009 S.O. No. :	Drawing Number : D3570 REV.0
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : SMALL /MED FAB	Drawing Revision : <i>8 E E</i>
Previous Run : 44908	Material :
Written By :	Due Date : 10/05/2009 Qty: 6 Um: Each
Checked & Approved By : <i>JUD 09.04.27</i>	
Comment : Est Rev:A New Issue 07-03.26 ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S125	6061-T6 .125 Sheet
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Comment: Qty.: 0.0746 sf(s)/Unit Total : 0.4473 sf(s)

6061-T6 .125 Sheet

Batch: *110062* *1B9-4-29*

Grain must be Along 4.63**

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3570

Dwg Rev: *E* *1B9-4-29*

Prog Rev: *E*

2-Deburr if necessary *1B9-4-29*



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1B9-4-29

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 09/04/29 *(XS)*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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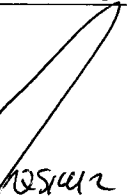
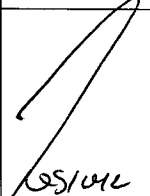
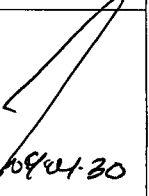
Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Form as per Dwg D3570 Using DT8945

FF 09-04-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3570-2 PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: D Date: 09/04/06
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>47532</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/04/30	5.0	edge to hole under Tolerance (.331 & .317) should be .365 ground too much, by hand. R.C. Human error / process.		Scrap: no replace qty 2	FF 09/04/30	S 09/04/30		

NOTE: Date & initial all entries

Date: Monday, 27/04/2009 12:51:16 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 47532

Part Number: D35702

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Cut excess materials per Dwg D3570.

3-Drill as per Dwg D3570 Using Dt8946

FF 09-04-30

(7)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/04/30 (x7)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 09-04-30 (7)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

13:25

OVEN TEMPERATURE:

320°

FINISH TIME:

13:55

UMD/Fd

09/04/30 (x7)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-01 G

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location:

5245A

09/05/01 (7)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/04

Job Completion



MF 09-05-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 47532
Description: BRACKET		Part Number: D3570-2
Inspection Dwg: D3570-2 Rev: E		Page 1 of 1

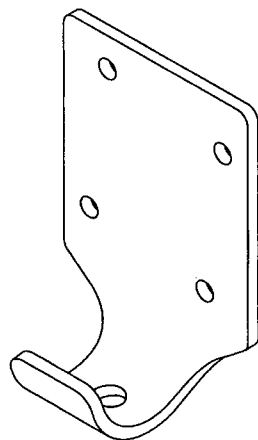
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

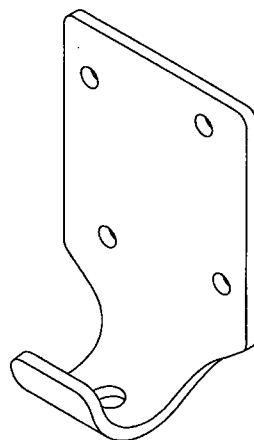
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .209	+0.05 - .001	.213	X			
.311	+/- .010	.312	✓			
.533	+/- .010	.531	✓			
1.717	+/- .010	1.719	✓			
1.939	+/- .010	1.937	✓			
2.25	+/- .030	2.255	✓			
.359	+/- .010	.359	✓			
.557	+/- .010	.552	✓			
1.943	+/- .010	1.942	✓			
2.141	+/- .010	2.141	✓			
2.50	+/- .030	2.50	✓			
4.75	+/- .030	4.755	✓			
.63	+/- .030	.627	✓			
1.63	+/- .030	1.631	✓			
.125	+/- .010	.124	✓			

Measured by: RB	Audited by: S	Prototype Approval: n/a
Date: 9-4-21	Date: 02/04/21	Date: 1/4

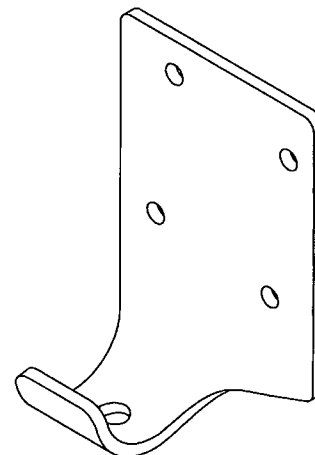
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



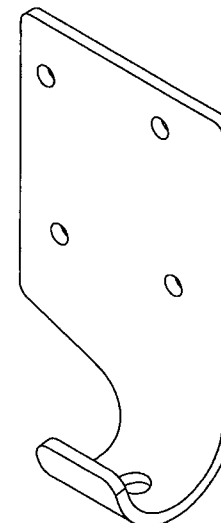
D3570-1 BRACKET



D3570-2 BRACKET



D3570-3 BRACKET



D3570-4 BRACKET

RELEASED
09/04/22

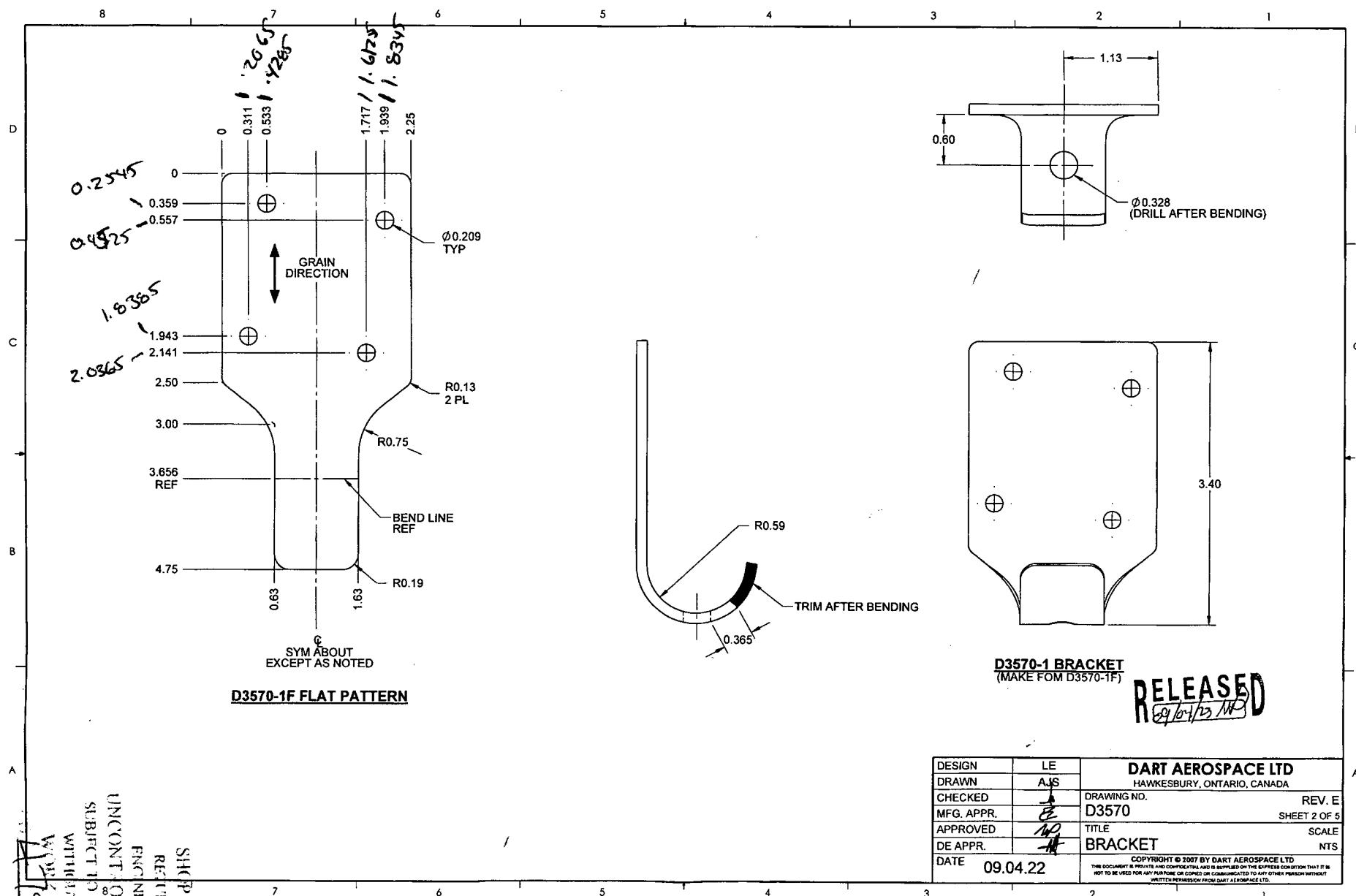
NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3570-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 LBS EACH

E	SHEET 3 UPDATED D3570-3F FLAT PATTERN, SEE REV D FOR DETAILS. SEE PAR 09-014.	AJS	09.04.22
D	ADDED -3 & -4 FOR USE ON 214B/B1. SEE PAR 09-014.	AJS	09.04.01
C	UPDATE DIMS FOR CLARITY	LE	07.06.01
B	CHANGE BEND RAD TO 0.60 FROM 0.50	LE	07.04.16
A	NEW ISSUE	LE	07.02.07
REV	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3570	SHEET 1 OF 5
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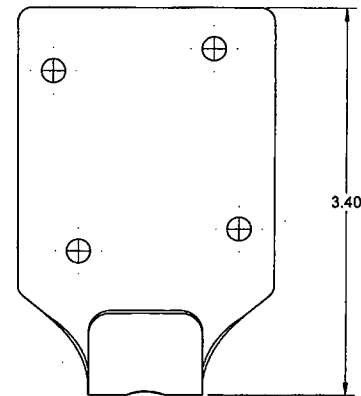
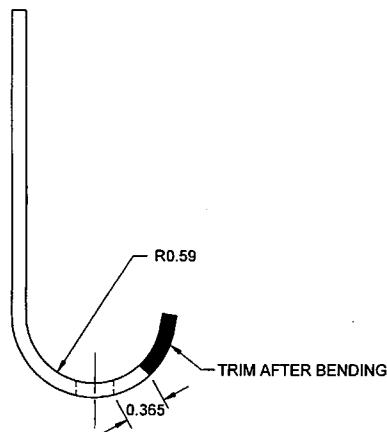
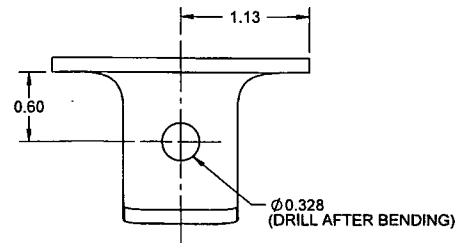
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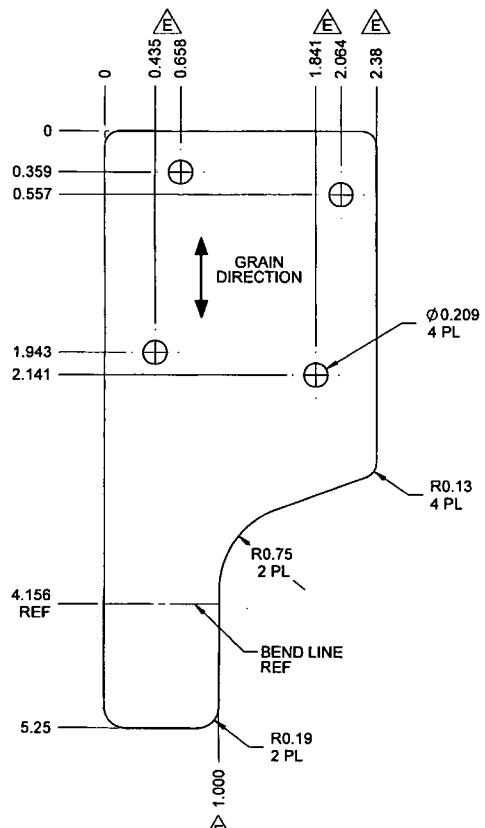


D3570-2 BRACKET
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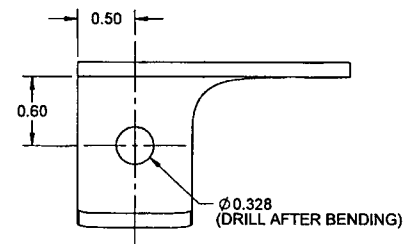
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MFG. APPR.	<i>[Signature]</i>	D3570	SHEET 3 OF 5
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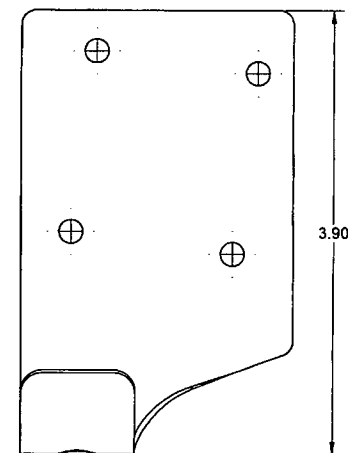
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D3570-3F FLAT PATTERN



D3570-3 BRACKET
(MAKE FROM D3570-3F)

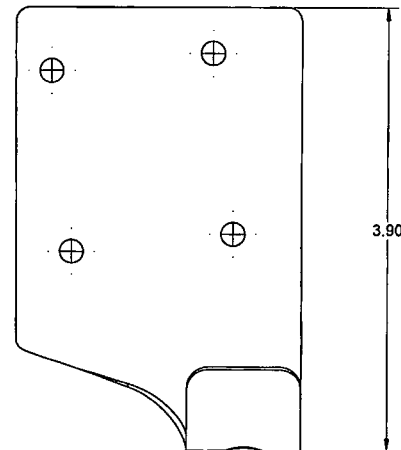
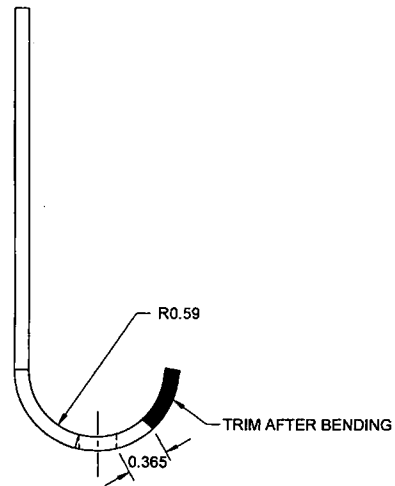
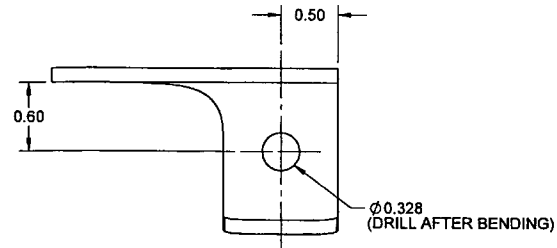


D3570-3 BRACKET
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D3570-4 BRACKET
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MFG. APPR.	<i>[Signature]</i>	SHEET 5 OF 5	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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